

Monday, 08/07/2008 1:39 PM
User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 40349
Estimate Number : 13332
P.O. Number :
This Issue : 07/07/2008 S.O. No. :
Prsht Rev. : NC
First Issue : / / Type : SMALL /MED FAB
Previous Run : 39362
Written By :
Checked & Approved By : JUD 08.7.07
Comment : Est Rev:A 08-05-20 new issue DD verified by:ec

Drawing Name : HANDLE ASSEMBLY (INTERIOR) *split*
Part Number : D3779043
Drawing Number : D3779 REV A
Project Number : N/A
Drawing Revision : A
Material :
Due Date : 28/07/2008 Qty: 10 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S125 6061-T6 .125 Sheet



Comment: Qty.: 0.4583 sf(s)/Unit Total : 4.5833 sf(s)
6061-T6 .125 Sheet
batch: 106634 HB 8-7-15

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
1-Cut as per Dwg D3779
Dwg Rev: A
Prog Rev: A

HB 8-7-15

(12)

2-Deburr if necessary

HB 8-7-15

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

808/14/15 (12)

(P10) →

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Pick Packing Kit

Dart Aerospace Ltd

W/O: 40349		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08/07/21	1.1	Small fab countersink and deburr	FF	08/07/23			
	1.2	QC 5	S	08/07/23	(12)		
	1.3	Chemical conversion - coat	FF	08/07/24	(12)		
	1.4	QC 3		08/07/24	(12X)		

Part No: D3779-013 PAR #: N/A Fault Category: Prod. Eng. Coordination NCR: Yes No DQA: D Date: 08/10/23
 (D412-698-035) QA: N/C Closed: 12 Date: 08/10/24

NCR: 40349		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/07/15	1.40	During A/C inspection it was found that the hole spacing of 6.960" is actually 7.000"		update program on water jet to correct Dwg. and ensure measurements are taken correctly	08/07/15			
		QC Program on water jet was not updated as per the Dwg. D3779-5, operator took Program from Prelm.		Screen and Destroy and replace Qty (12) BA M100634	08-15			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE ASSEMBLY (INTERIOR)

Job Number: 40349

Part Number: D3779043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D32031

Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Handle

batch:

30158A 3x B40353 9x

12/8/25 (12)

7.0

MS20426AD10 18

Rivet Countersunk



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Rivet Countersunk

batch:

1107936

or (MS20426AD10-10)

12

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

12/8/21

1- counter sink holes as per dwg D3779

2- deburr

3- rivet D3203-1 handle to D3779-5 plate as per dwg D3779 per QSI003

FF 08/10/22

(8)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/10/22 (x8)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location:

51238A

12/8/23 (8)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/23

Job Completion



12 08/10.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Proportion

7

115

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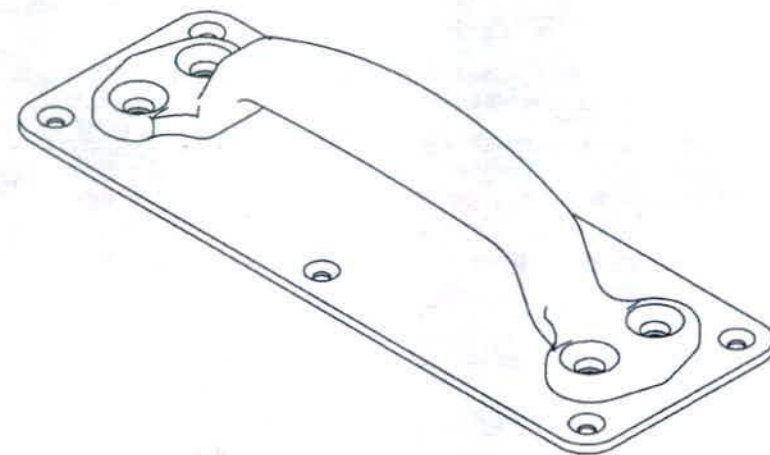
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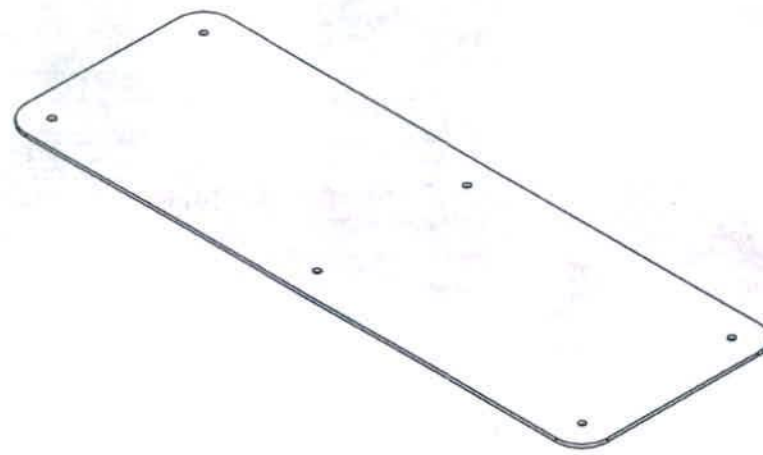
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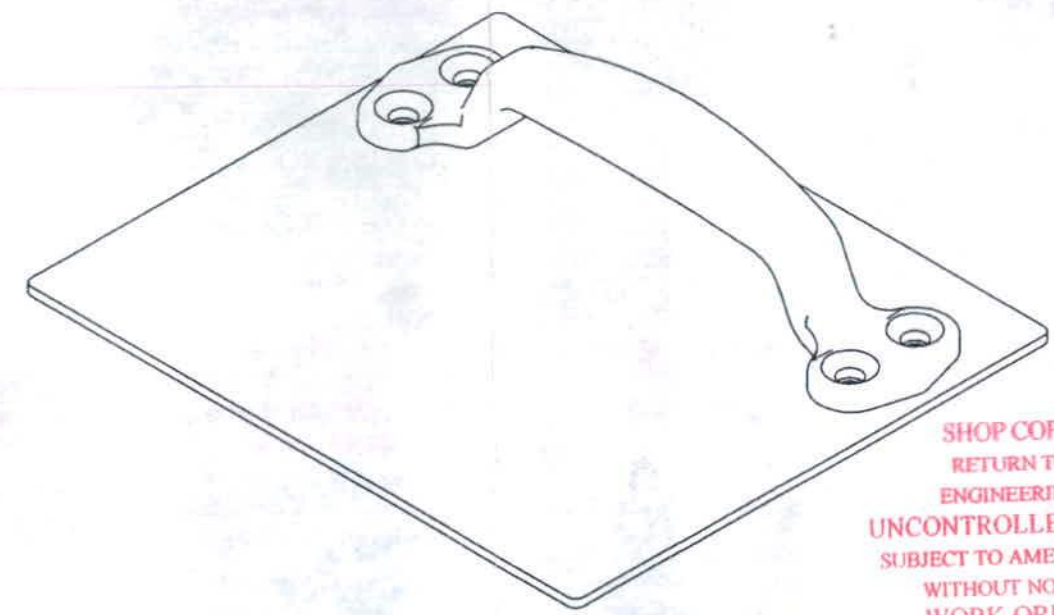
QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
X		D3779-041	HANDLE ASSEMBLY
	X	D3779-043	HANDLE ASSEMBLY
1	1	D3203-1	HANDLE
1		D3779-1	PLATE
	1	D3779-5	PLATE
4	4	MS20426AD10-8	RIVET, CSK



D3779-041 HANDLE ASSEMBLY
(EXTERIOR)



D3779-3 DOUBLER PLATE

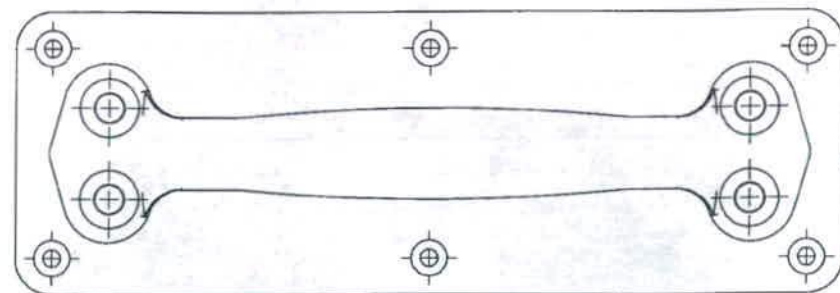


D3779-043 HANDLE ASSEMBLY
(INTERIOR)

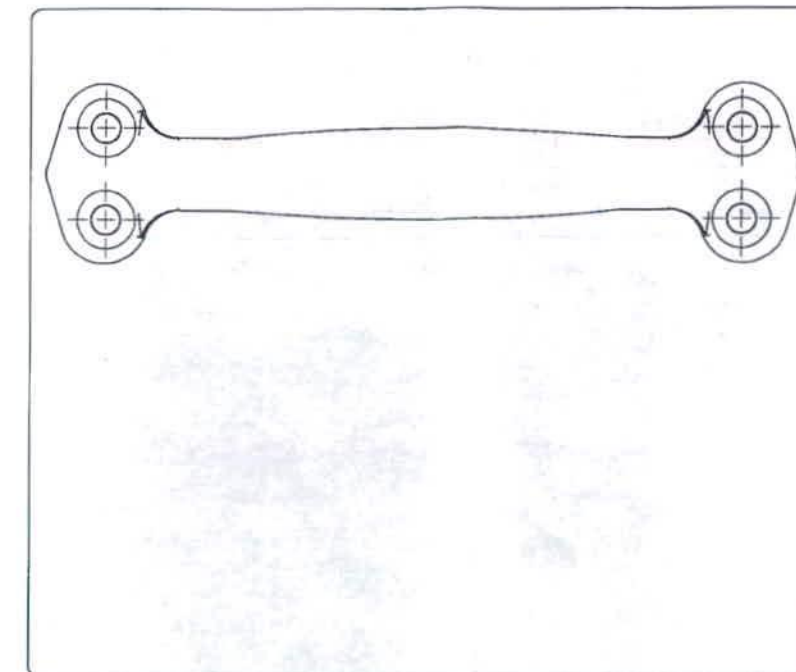
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WORK ORDER
NO. 40349

RELEASED
08.06.26 MP

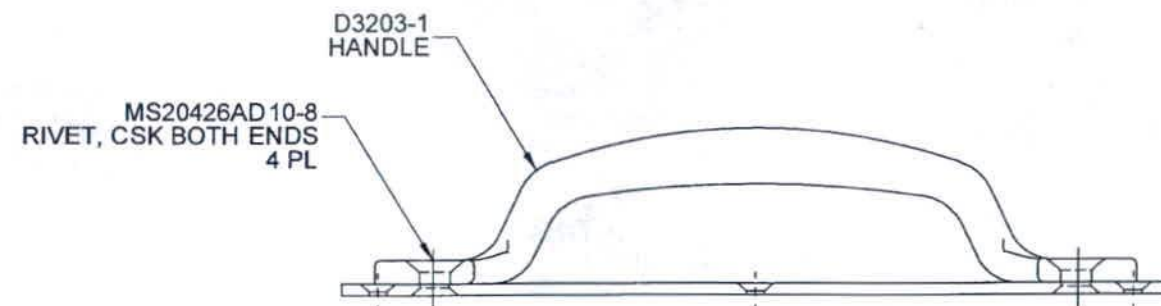
A	NEW ISSUE	AJS	08.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3779	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		HANDLE ASSEMBLY, CABIN SLIDING DOOR	NTS
DATE	08.04.21	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



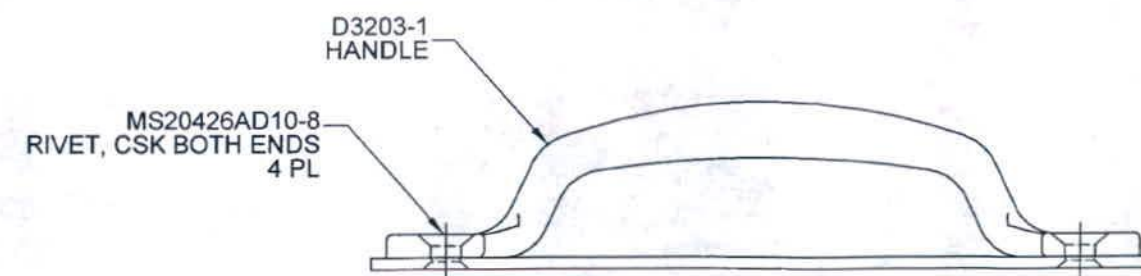
D3779-1
PLATE



D3779-5
PLATE



D3779-041 HANDLE ASSEMBLY
(EXTERIOR)



D3779-043 HANDLE ASSEMBLY
(INTERIOR)

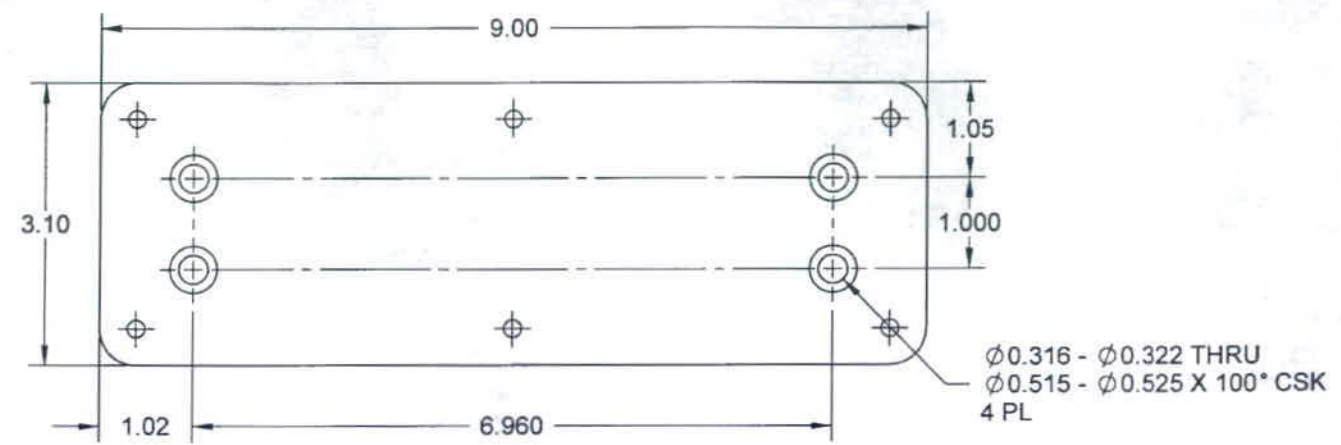
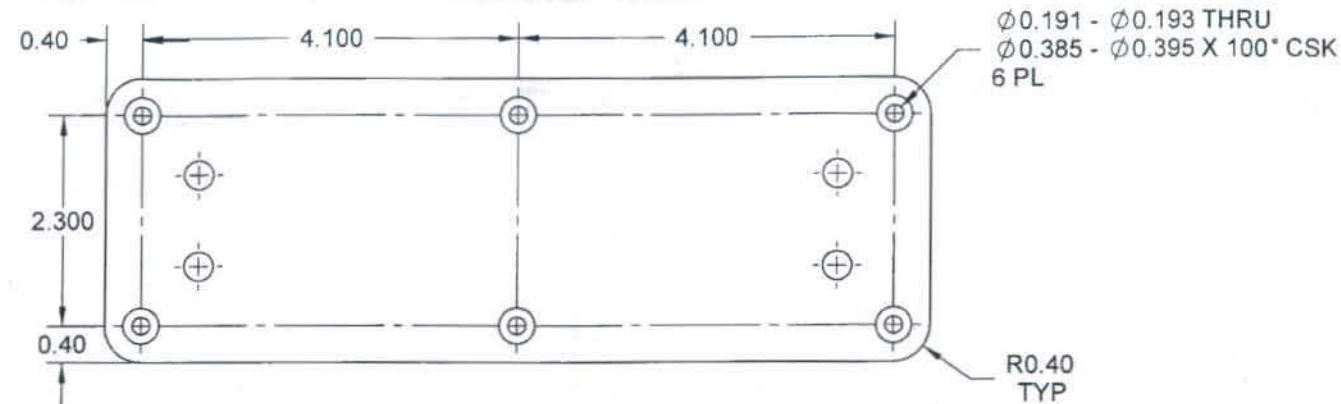
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08.06.26/18

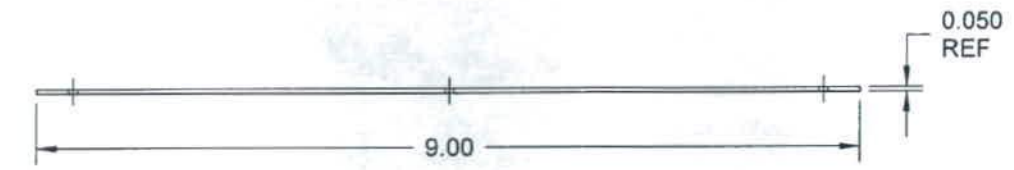
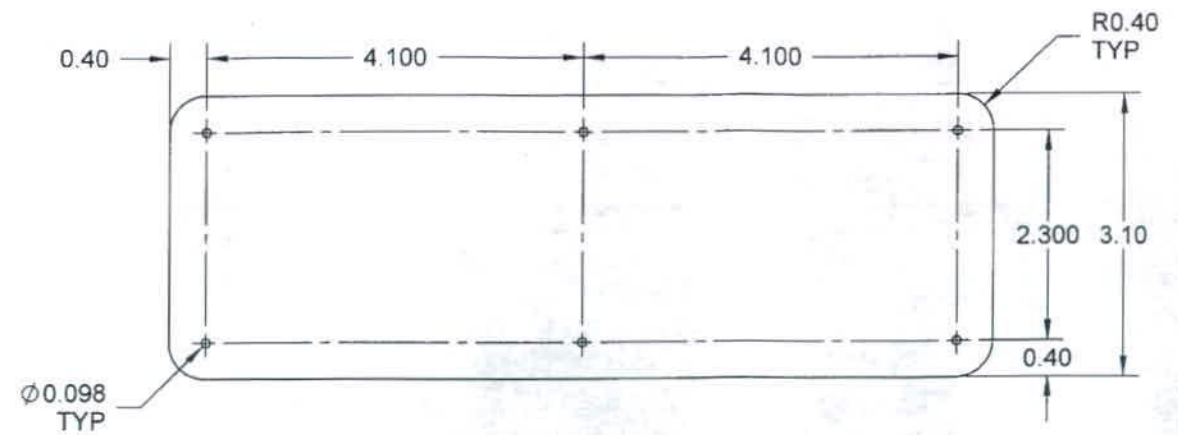
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3779-041" USING FINE POINT PERMANENT INK MARKER
 - 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3779-043" USING FINE POINT PERMANENT INK MARKER
 - 8) WEIGHT: 0.71 lbs APPROX (-041)
 - 9) WEIGHT: 1.14 lbs APPROX (-043)

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MFG. APPR.		D3779	SHEET 2 OF 4
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8 7 6 5 4 3 2 1



D3779-1 PLATE



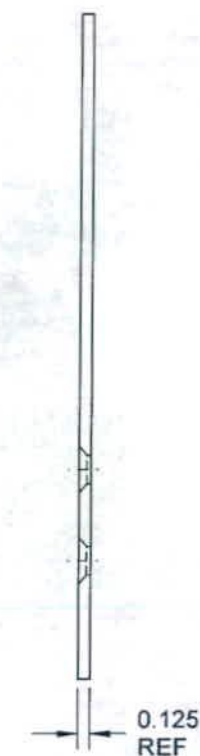
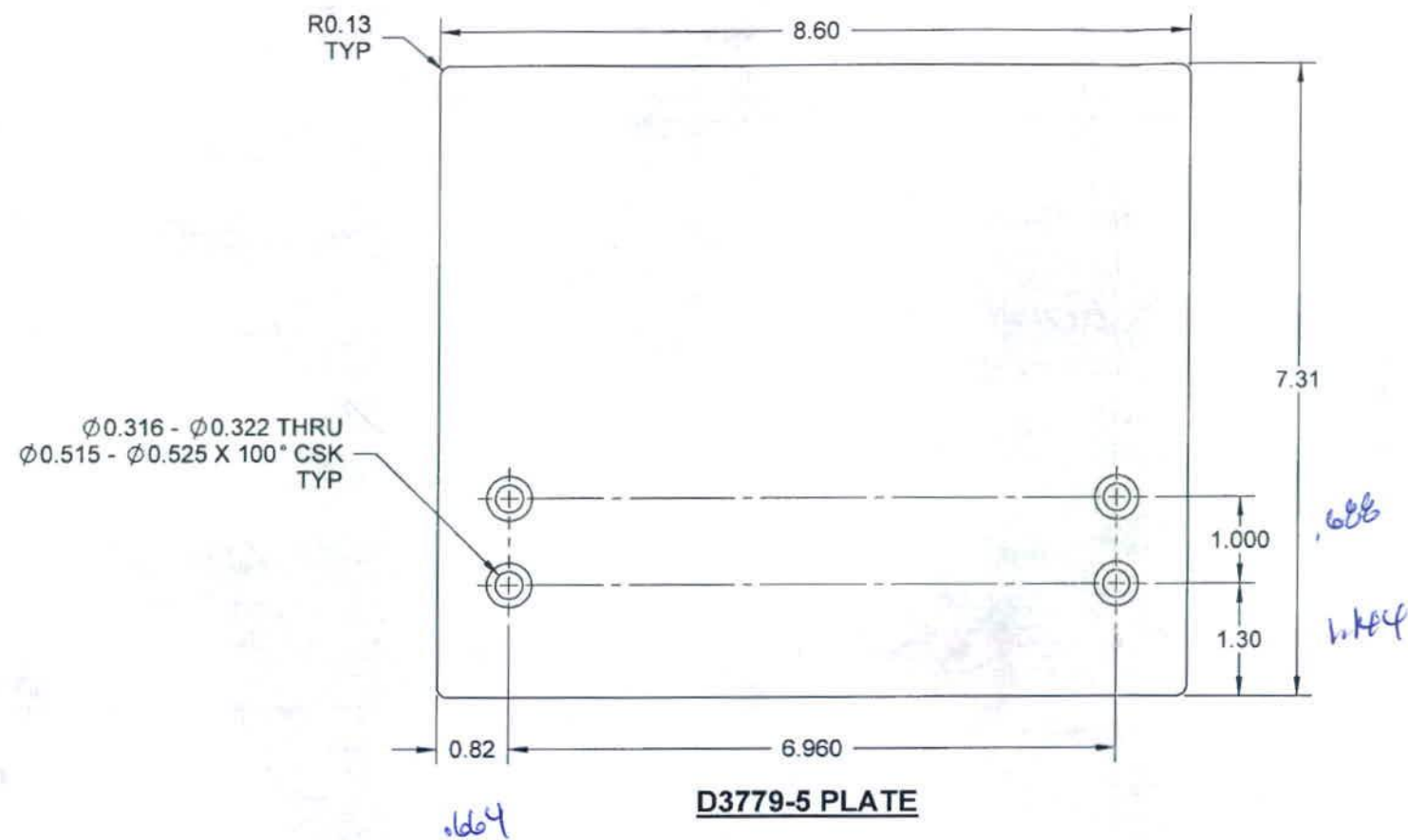
D3779-3 PLATE

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NO. 40349

RELEASED
08-05-16

- NOTES:
- 1) MATERIAL: -1 PLATE:
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.125
-3 PLATE:
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.050
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3779-3" USING FINE POINT PERMANENT INK MARKER
(DO NOT IDENTIFY -1 & -5)
 - 7) WEIGHT: 0.14 lbs FOR -3.

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NOTES:

- 1) MATERIAL: -5 PLATE:
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE SHEET 2 FOR ASSEMBLED WEIGHT

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MFG. APPR.		D3779	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		HANDLE ASSEMBLY, CABIN SLIDING DOOR	NTS
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